

Work Order ID 76562

November-16-11 3:40:17 PM

76562

Page 1

Item ID: D3017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Back Frame Assembly
Start Date: 16/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 01/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 11/11/12 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: M118375 0.00
Large Fab

100

Large Fab

Large Fab

Memo

0.00

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

EL 11-11-22 XL

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1 8 BE11-11-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76562

November-16-11 3:40:17 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 16/11/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 01/12/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation	Description
1	Start of the program
2	Initial values of variables
3	Calculation of the first term
4	Calculation of the second term
5	Calculation of the third term
6	Calculation of the fourth term
7	Calculation of the fifth term
8	Calculation of the sixth term
9	Calculation of the seventh term
10	Calculation of the eighth term
11	Calculation of the ninth term
12	Calculation of the tenth term
13	Calculation of the eleventh term
14	Calculation of the twelfth term
15	Calculation of the thirteenth term
16	Calculation of the fourteenth term
17	Calculation of the fifteenth term
18	Calculation of the sixteenth term
19	Calculation of the seventeenth term
20	Calculation of the eighteenth term
21	Calculation of the nineteenth term
22	Calculation of the twentieth term
23	Calculation of the twenty-first term
24	Calculation of the twenty-second term
25	Calculation of the twenty-third term
26	Calculation of the twenty-fourth term
27	Calculation of the twenty-fifth term
28	Calculation of the twenty-sixth term
29	Calculation of the twenty-seventh term
30	Calculation of the twenty-eighth term
31	Calculation of the twenty-ninth term
32	Calculation of the thirtieth term
33	Calculation of the thirty-first term
34	Calculation of the thirty-second term
35	Calculation of the thirty-third term
36	Calculation of the thirty-fourth term
37	Calculation of the thirty-fifth term
38	Calculation of the thirty-sixth term
39	Calculation of the thirty-seventh term
40	Calculation of the thirty-eighth term
41	Calculation of the thirty-ninth term
42	Calculation of the fortieth term
43	Calculation of the forty-first term
44	Calculation of the forty-second term
45	Calculation of the forty-third term
46	Calculation of the forty-fourth term
47	Calculation of the forty-fifth term
48	Calculation of the forty-sixth term
49	Calculation of the forty-seventh term
50	Calculation of the forty-eighth term
51	Calculation of the forty-ninth term
52	Calculation of the fiftieth term
53	Calculation of the fifty-first term
54	Calculation of the fifty-second term
55	Calculation of the fifty-third term
56	Calculation of the fifty-fourth term
57	Calculation of the fifty-fifth term
58	Calculation of the fifty-sixth term
59	Calculation of the fifty-seventh term
60	Calculation of the fifty-eighth term
61	Calculation of the fifty-ninth term
62	Calculation of the sixtieth term
63	Calculation of the sixty-first term
64	Calculation of the sixty-second term
65	Calculation of the sixty-third term
66	Calculation of the sixty-fourth term
67	Calculation of the sixty-fifth term
68	Calculation of the sixty-sixth term
69	Calculation of the sixty-seventh term
70	Calculation of the sixty-eighth term
71	Calculation of the sixty-ninth term
72	Calculation of the seventieth term
73	Calculation of the seventy-first term
74	Calculation of the seventy-second term
75	Calculation of the seventy-third term
76	Calculation of the seventy-fourth term
77	Calculation of the seventy-fifth term
78	Calculation of the seventy-sixth term
79	Calculation of the seventy-seventh term
80	Calculation of the seventy-eighth term
81	Calculation of the seventy-ninth term
82	Calculation of the eightieth term
83	Calculation of the eighty-first term
84	Calculation of the eighty-second term
85	Calculation of the eighty-third term
86	Calculation of the eighty-fourth term
87	Calculation of the eighty-fifth term
88	Calculation of the eighty-sixth term
89	Calculation of the eighty-seventh term
90	Calculation of the eighty-eighth term
91	Calculation of the eighty-ninth term
92	Calculation of the ninetieth term
93	Calculation of the ninety-first term
94	Calculation of the ninety-second term
95	Calculation of the ninety-third term
96	Calculation of the ninety-fourth term
97	Calculation of the ninety-fifth term
98	Calculation of the ninety-sixth term
99	Calculation of the ninety-seventh term
100	Calculation of the ninety-eighth term
101	Calculation of the ninety-ninth term
102	Calculation of the hundredth term
103	Calculation of the hundred-first term
104	Calculation of the hundred-second term
105	Calculation of the hundred-third term
106	Calculation of the hundred-fourth term
107	Calculation of the hundred-fifth term
108	Calculation of the hundred-sixth term
109	Calculation of the hundred-seventh term
110	Calculation of the hundred-eighth term
111	Calculation of the hundred-ninth term
112	Calculation of the hundred-tenth term
113	Calculation of the hundred-eleventh term
114	Calculation of the hundred-twelfth term
115	Calculation of the hundred-thirteenth term
116	Calculation of the hundred-fourteenth term
117	Calculation of the hundred-fifteenth term
118	Calculation of the hundred-sixteenth term
119	Calculation of the hundred-seventeenth term
120	Calculation of the hundred-eighteenth term
121	Calculation of the hundred-nineteenth term
122	Calculation of the hundred-twentieth term
123	Calculation of the hundred-twenty-first term
124	Calculation of the hundred-twenty-second term
125	Calculation of the hundred-twenty-third term
126	Calculation of the hundred-twenty-fourth term
127	Calculation of the hundred-twenty-fifth term
128	Calculation of the hundred-twenty-sixth term
129	Calculation of the hundred-twenty-seventh term
130	Calculation of the hundred-twenty-eighth term
131	Calculation of the hundred-twenty-ninth term
132	Calculation of the hundred-thirtieth term
133	Calculation of the hundred-thirty-first term
134	Calculation of the hundred-thirty-second term
135	Calculation of the hundred-thirty-third term
136	Calculation of the hundred-thirty-fourth term
137	Calculation of the hundred-thirty-fifth term
138	Calculation of the hundred-thirty-sixth term
139	Calculation of the hundred-thirty-seventh term
140	Calculation of the hundred-thirty-eighth term

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00.

140

QC3- Inspect Part Finish

0.00

140

OC

Memo

0.00

Quality Control

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NOTE: Date & initial all entries

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Work Order ID 76562

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Page 3

November-16-11 3:40:17 PM

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 Revision ID: Stop ***NS2***
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 Start Date: 16/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

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11/11/24

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11/11/24

[Handwritten signature]
11/11/24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 76562

76562

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 16/11/2011

Required Date: 01/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083		Purchased	No			100	f	53.4370	2.458	2.587368			
M4130NT0 750W 083										**		EL 11-11-22	
4130 RD Tube .750 x.083W													
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>					
			MAT033			53.437							
			117579			29.52						2.58	
			117973			23.917							
M4130NT0.750W.049		Purchased	No			100	f	105.5500	11.125	11.71053			
M4130NT0 750W 049										**		EL 11-11-22	
4130 RD Tube .750 x.049W													
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>					
			MAT033			105.55							
			117973			33.55						11.7	
			118772			72							
D3017-11		Manufactured	No			100	Each	11.0000	2	2			
D3017-11										**		EL 11-11-22	
cap													
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>					
			WA			11							
			69074			11						2	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

November-16-11 3:40:21 PM

Work Order ID: 76562

76562

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 16/11/2011

Required Date: 01/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3017-7

Manufactured No

100

Each

25.0000

3

3

D3017-7

EL 11-11-22

Lug

Location

Loc Qty

Loc Code

WA

9

69166

1

70905

8

WA019

1

52915

1

WA030

15

70871

15

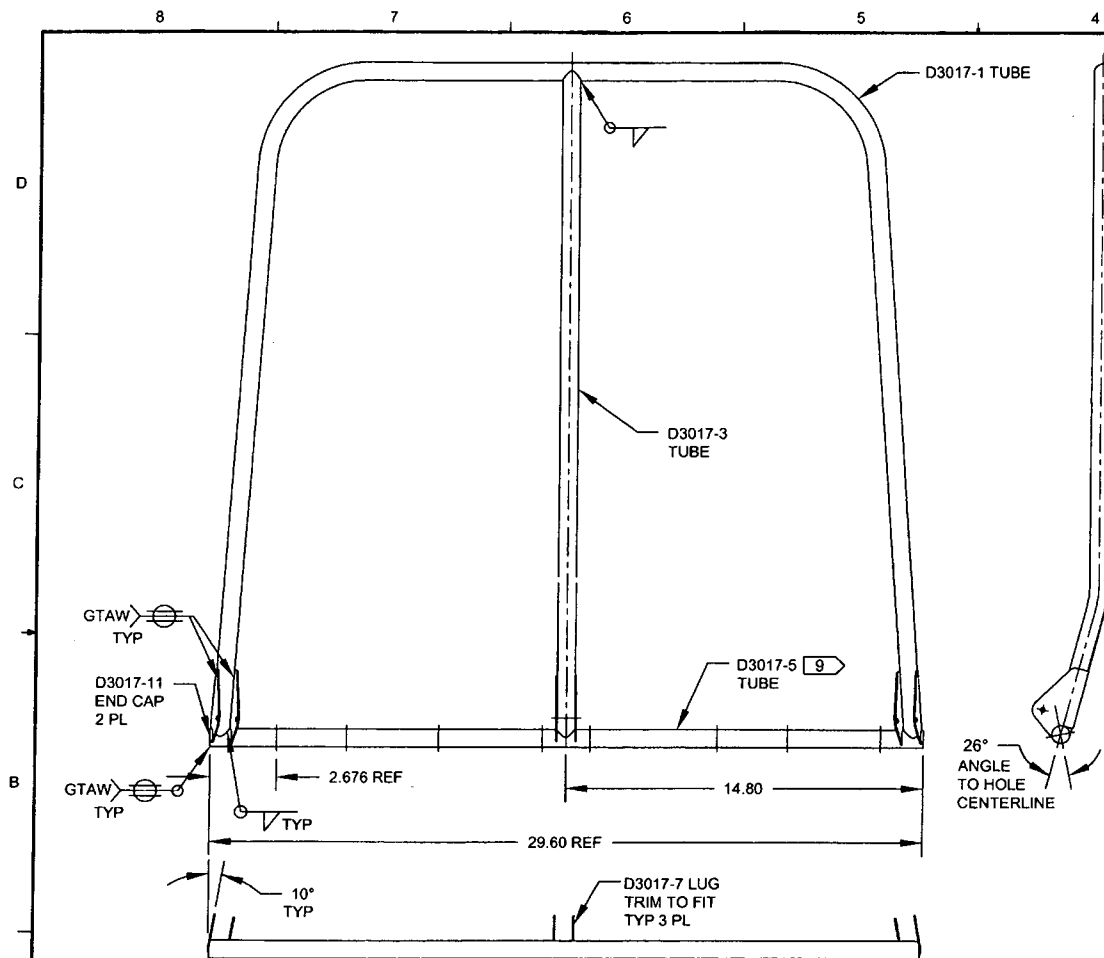
Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76562 M.L.J

11/11/17

RELEASED
2010-02-02
mp

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

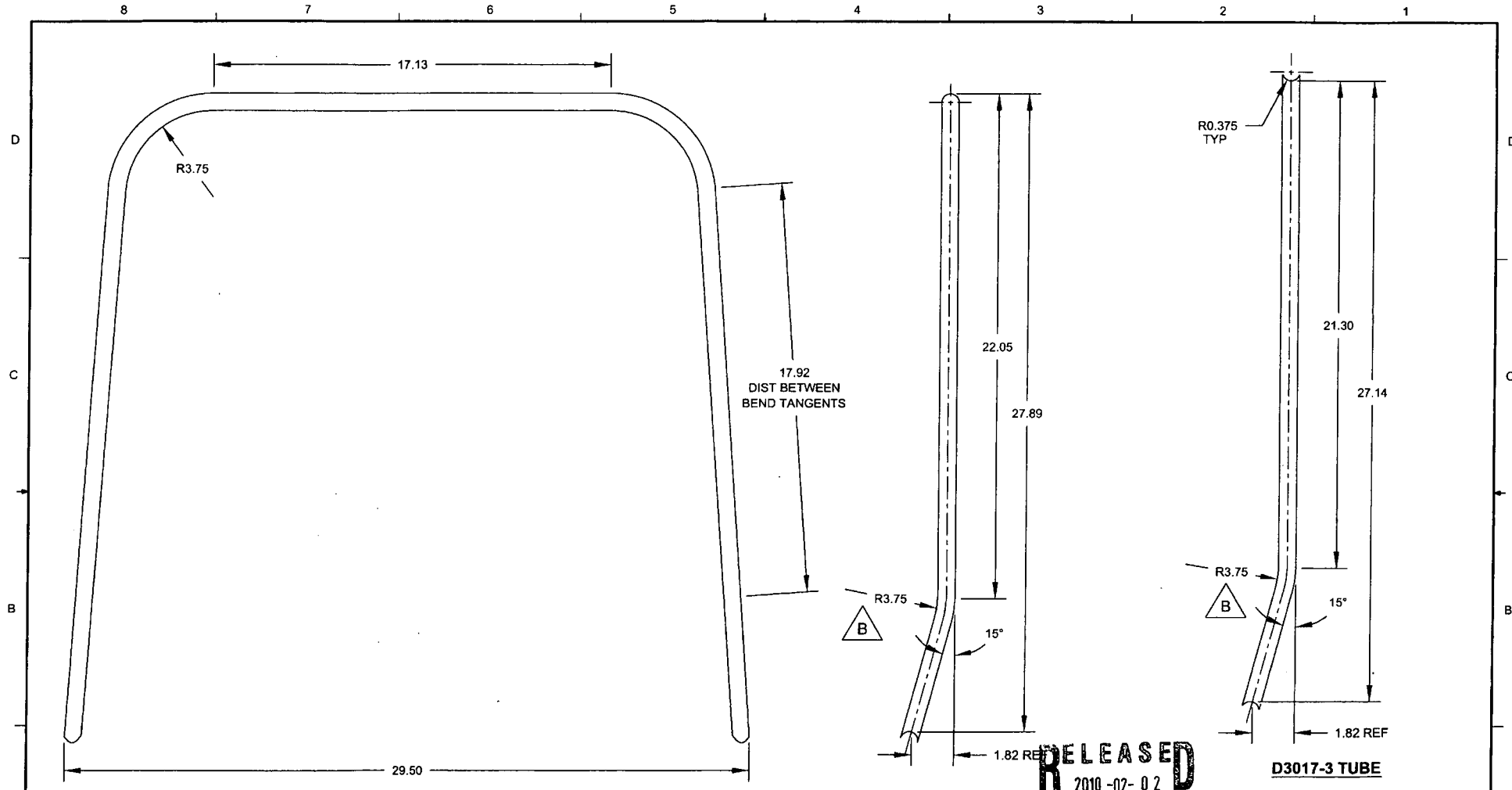
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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76562



D3017-1 TUBE

D3017-3 TUBE

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

RELEASED
2010-02-02
JW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

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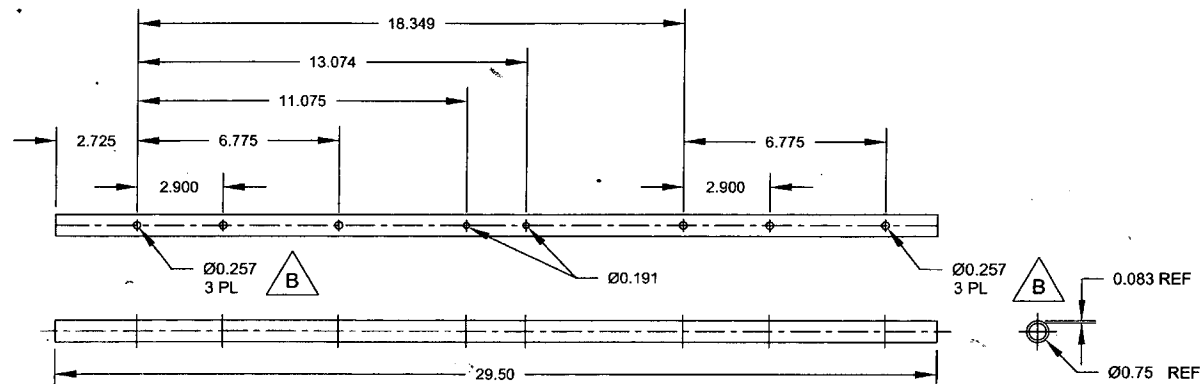
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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76562



D3017-5 TUBE

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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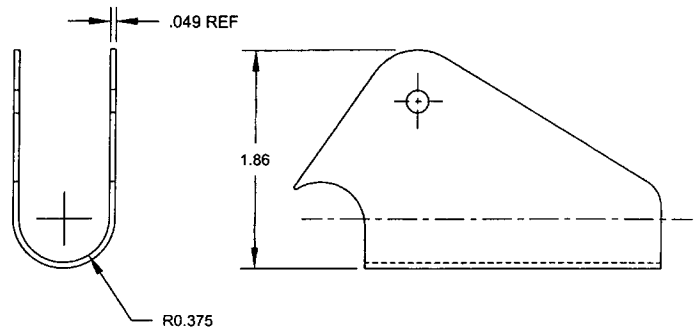
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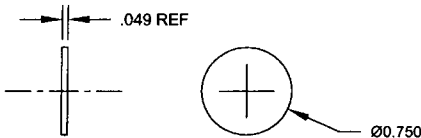
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B

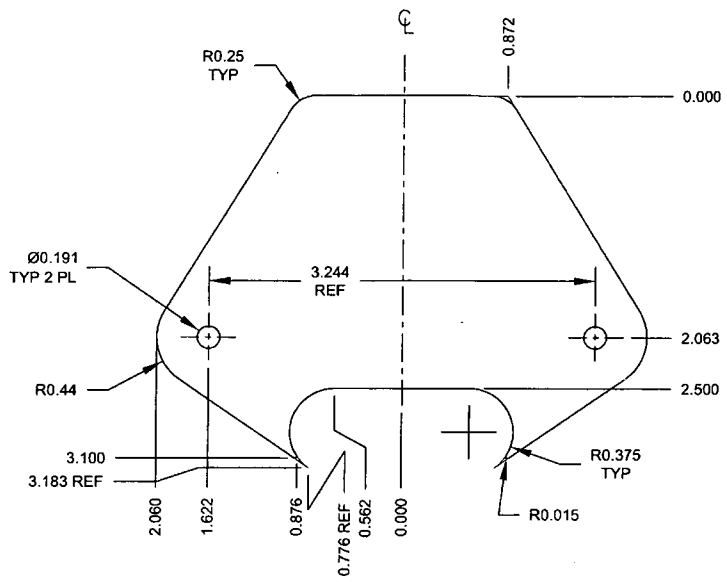
A



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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